

15/2008 1:20:02 PM

Process Sheet

2001 Dart Helicopters Services

Drawing Name : PIVOT ARM

13/05/2008 S.O. No. :

Part Number : 41232 200 002 005

Drawing Number : 41232-200-002 REV A

Project Number : N/A

Drawing Revision : A

Material :

Due Date : 05/06/2008

Qty: 6 Um: Each

Ent Rev.

NC

First Issue

13/05/2008

Type

MACHINED PARTS

Previous Run

31778

Written By

Checked & Approved By

Comment

Est Rev:A New Issue 07-03-05 JLM

Est Rev:B Now on Doosan Lathe 08-05-13 JLM Verified

By:DD

Additional Product

Job Number:

Seq. #:

Machine Or Operation:

Description :

1.0

M2024T3R1250

2024-T3 Round Bar 1.250"

Comment: Qty.: 0.3675 f(s)/Unit Total : 2.2050 f(s)

2024-T3 Round Bar 1.250"

Batch: 103753

2.0

DOOSAN LATHE

DOOSAN LATHE

Comment: Doosan Lathe

1- Turn as per Folio FA745 Rev. A & Dwg 41232-200-002 Rev. A

2-Deburr

3.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0

QC8

SECOND CHECK

Comment: SECOND CHECK

5.0

OUTSIDE SERV.30

OUTSIDE SERVICES-MACH

Comment: Sub-Contracting PURCHASING

Issue P/O: 0520

Black Anodize as per Dwg 41232-200-005

Ensure Certificate of Conformity is attached

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PIVOT ARM

Job Number: 39217

Part Number: 41232 200 002 005

Job Number:



Seq. #: Machine Or Operation: Description :

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Receive & Inspect For Transit Damage

Ensure certificate of conformity is attached

Ref/15 (7)

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

S 08/06/20

8.0

MS21209F410

heli-coil



Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

HeliCoil 1/4"-28NF(RED)

Batch:

M104030 x4 M108085 x3

AS 08/06/23 (7)

9.0

MILLING CONV.

CONVENTIONAL MILLING MACHINE



Comment: CONVENTIONAL MILLING MACHINE

Install Helicoil as per Dwg 41232-200-005.

FF 08-06-24 (7)

10.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/06/24 (16)

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

ST 365

AS 08/06/24 (16)

12.0

QC21

FINAL INSPECTION/W/O RELEASE



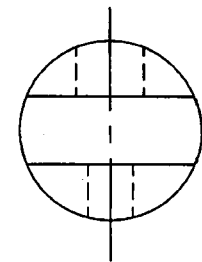
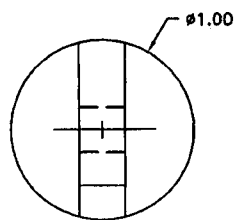
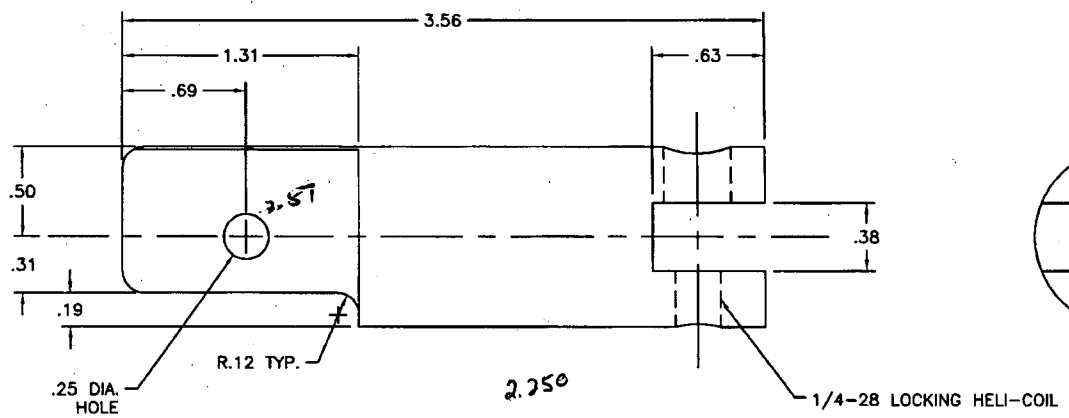
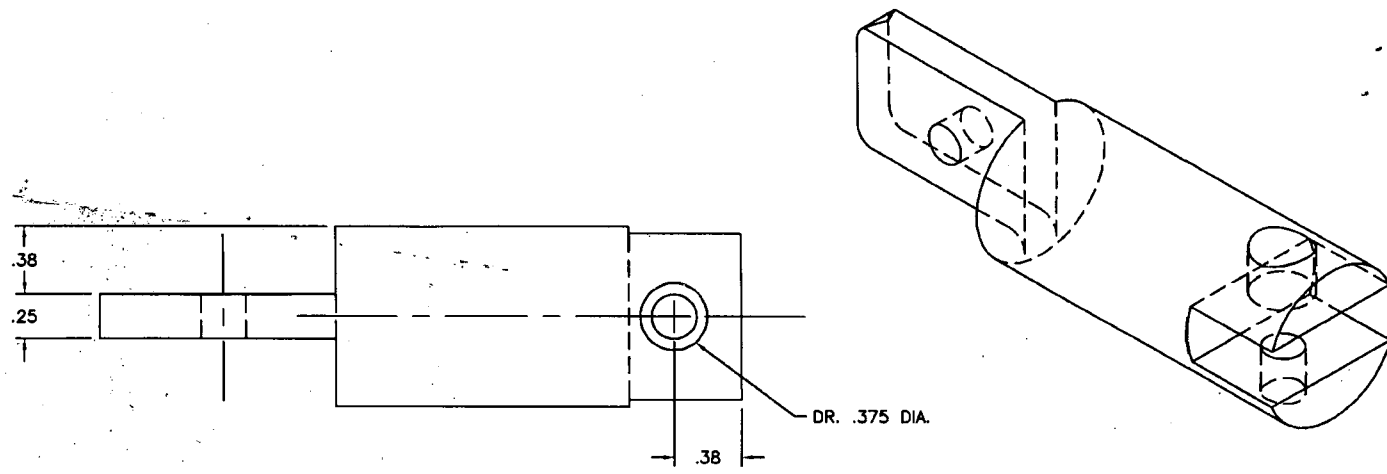
Comment: FINAL INSPECTION/W/O RELEASE

08/06/25

Job Completion



C208/06/25



-005 PIVOT ARM

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WORK ORDER
NO. 39217

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Era Aviation, Inc.

TITLE	SIZE	DRW. NO.	REV.
STEP ACTUATOR COMPONENTS	C	41232-200-002 SHT 3 OF 3	A

DATE 2/26/04	ENGINEERING ORDER	E.O. No. B-1	SHT. 1 OF 1
BY D. NELSON		DWG. AFFECTED 41232-200-002	
APPROVED BY		SHEET AFFECTED SHT 1 & 3	
TITLE STEP ACTUATOR COMPONENTS			

REASON FOR CHANGE: CHANGED DASH NO. OF INSERT ON L/M; CHANGED INSERT CALLOUT ON -005 PIVOT ARM.

MINOR CHANGE - FAR 21.95

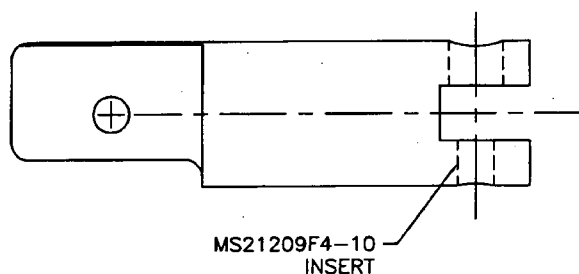
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WAS

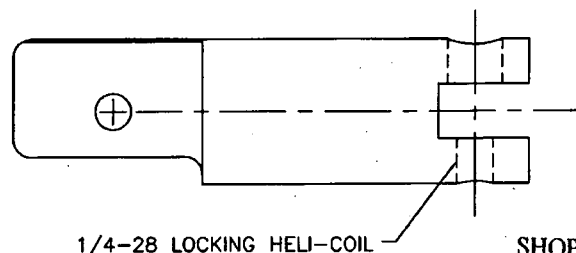
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IS



-005 PIVOT ARM

WAS



-005 PIVOT ARM

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CHANGE REQUIRED:	DATE:	BY:	YES	NO
TRAVELER				
INSTALLATION INSTRUCTIONS				
MAINTENANCE INSTRUCTIONS				
ILLUSTRATED PARTS				
UNINCORPORATED DRAWING LIST				
MASTER DRAWING LIST				
COMPUTER DATA BASE				

DART AEROSPACE LTD		Work Order:	39217
Description: PIVOT ARM		Part Number:	41232-200-002-005
Inspection Dwg: 41232-200-002 Rev: A		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
.38	+/- .03	.375				
.25	+/- .03	.250				
.38	+/- .03	.380				
.375 ϕ	+/- .010	.375				
1.00 ϕ	+/- .03	1.000				
3.56	+/- .03	3.565				
1.31	+/- .03	1.308				
.63	+/- .03	.630				
.50	+/- .03	.500				
.38	+/- .03	.375				
.31	+/- .03	.310				
.19	+/- .03	.190				
R.12	+/- .03	R.125				
.25 ϕ	+/- .03	.250				
1/4-28 AC	N/A					

Measured by: <i>[Signature]</i>	Audited by: <i>[Signature]</i>	Prototype Approval: <i>N/A</i>
Date: 08/05/14	Date: 08-03-14	Date: <i>N/A</i>

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

I NIMI

ANODISATION et PEINTURE TNM INC.

C. OF C

21 chemin de l'Aviation, Pointe Claire QC H9R 4Z2

Telephone: (514) 429-7777 Fax: (514) 429-5108

Certifié ISO 9001-2000 certified
approuvé NADCAP approved

65597

11-Jun-2008

CLIENT / CUSTOMER:**DART AEROSPACE LTD.**

1270 ABERDEEN STREET

HAWKESBURY , ONTARIO

K6A 1K7

**CERTIFICATE OF COMPLIANCE
CERTIFICAT DE CONFORMITE****NO. DE COMMANDE:
PURCHASE ORDER/ 6520**

ITEM	COMMANDE ORDERED	EXPEDIE SHIPPED	PART NUMBER & DESCRIPTION	PART PROCESS & TREATMENT
1	7	7	412-200-002-005 B39	DWG: D41232-200-002 REV. A
4	8	8	D3299-1 B38451	BLACK ANODIZE PER MIL-8625F1, CLASS 2 TYPE 2 DWG: D2399 REV. B
2	62	62	D2348 B39578	BLUE ANODIZE PER MIL-8625F1, CLASS 2 TYPE 2 DWG: D2348 REV. B2
3	62	62	D2348 B39666	BLACK ANODIZE PER MIL-8625F1, CLASS 2 TYPE 2 DWG: D2348 REV. B2
				BLACK ANODIZE PER MIL-8625F1, CLASS 2 TYPE 2

Last Modified on 20-Jun-2008

Nous certifions que les pièces énumérées ont été traitées, testées et inspectées selon les spécifications mentionnées.
Les cartes de travail ont été remplies et sont disponibles pour consultation, sur demande.

All parts are processed, tested, and inspected to the requirements of above specifications.

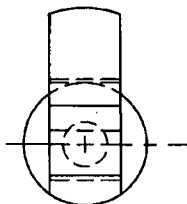
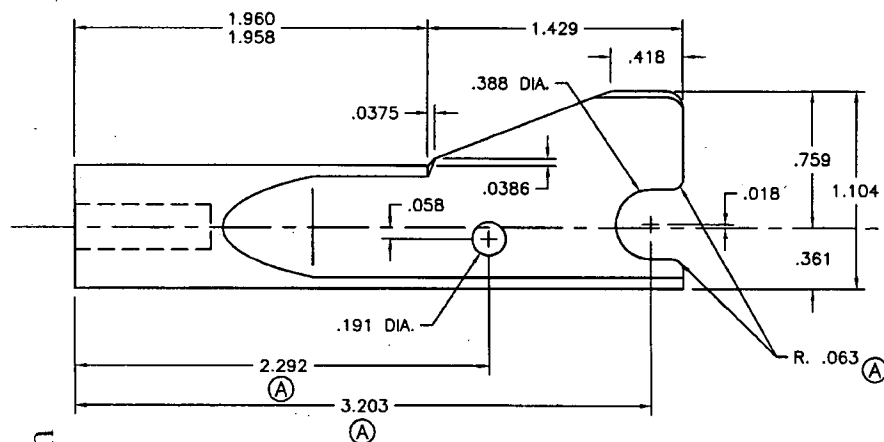
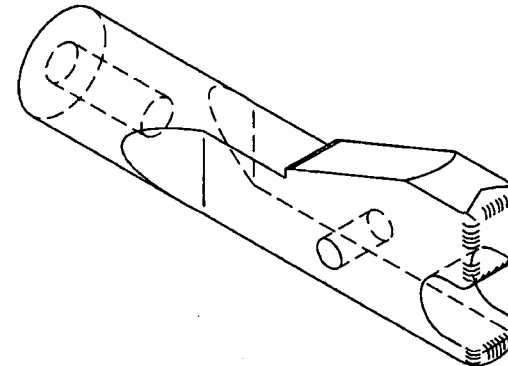
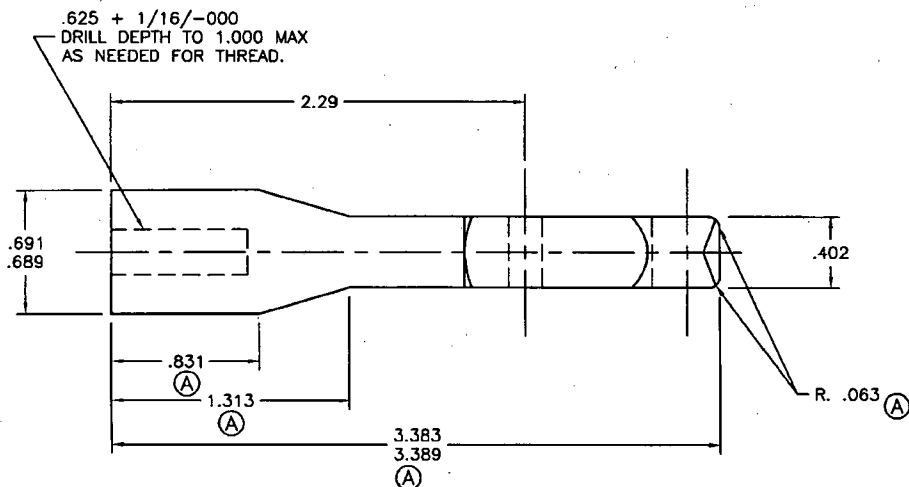
Travel cards have been filled and are available for viewing upon request.

NOTE: Painted Parts will be Fully Solvent Resistant after 7 (seven) Full Days of Air Curing at Ambient Temperatures"

NOTE: Les pièces peintes seront complètement résistantes au solvant après 7 (sept) jours complets de séchage à l'air ambiant.

Signature/Signed

Directeur de la Qualité / Q.A. Manager



-003 LATCH

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STEP ACTUATOR COMPONENTS	SIZE C	DWG. NO. 41232-200-002 SHT 2 OF 3	REV. A
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